

Customer	:	CU-DAR001 Dart Helicopters Services	Drawing Name	:	LUG	
Job Number	:	34671A				
Estimate Number	:	10839				
P.O. Number	:	N/A	Part Number	:	D22491	
This Issue	:	9/14/2007	Drawing Number	:	D2249 REV. E	
Prsht Rev.	:	NC	Project Number	:	N/A	
First Issue	:	N/A	Drawing Revision	:	E	
Previous Run	:	34115	Material	:	N/A	
Written By	:	<u>HA</u>	Due Date	:	10/20/2007	Qty: 30 Um: 10 Each
Checked & Approved By	:	<u>HA 07.09.17</u>				
Comment	:	Est: D 05.02.04 Added Step 9 KJ/RF				
		Est Rev:E Now on Waterjet 07-03-08 JLM				

[illegible][illegible]

Batch: m10S130 1807-09-19

[illegible]

SAD 07/09/20

30

[illegible]

07/09/21 (+30)

[illegible]

Location: 5722

02/7/21 (30)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DP Date: 01/09/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/14/2007 2:00:49 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 34671A

Part Number: D22491

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

INSPECT PARTS AS THEY COME OFF MACHINE



final w/o inspection



(30)

Comment: ~~INSPECT PARTS AS THEY COME OFF MACHINE~~

Date 9/21

Job Completion



U 9/21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

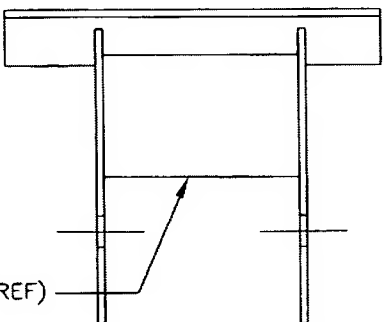
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

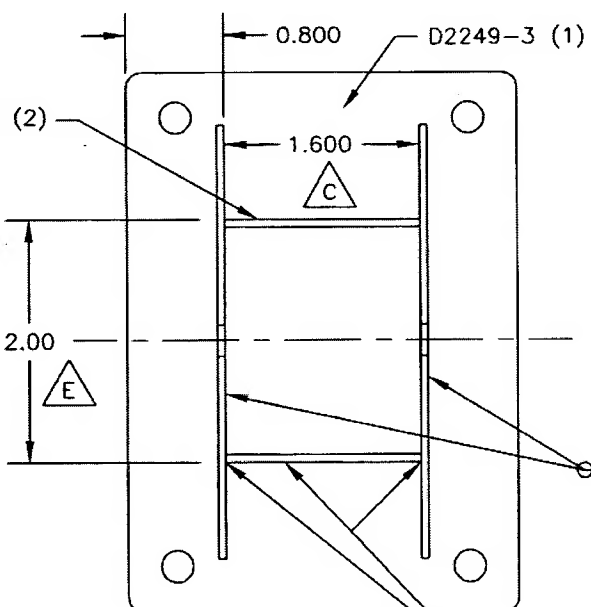
NOTE: Date & initial all entries

DART**RELEASED**
99.10.12 KCE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
AE	RF	CHECKED	APPROVED	REV. E
AE	RF	D2249	D2249	SHEET 1 OF 4
DATE		TITLE	SCALE	
99.09.20		FITTING	NIS	
A	94.06.20	NEW ISSUE		
B	95.11.30	DIMENSION CHANGE		
C	95.12.14	DIMENSION CHANGE		
D	98.04.30	Ø0.261 WAS Ø0.257 (TSR A179) REMOVED DUPLICATE DIMENSIONS		
E	99.09.20	ADDED GUSSET		



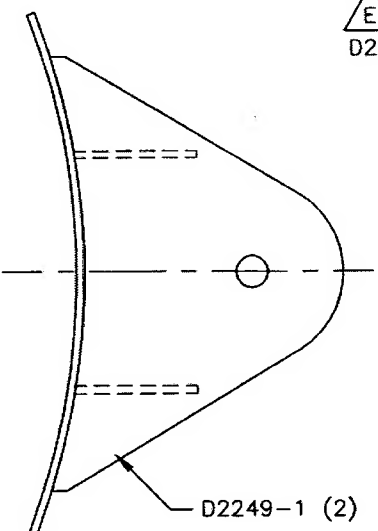
E D2249-5 (REF)

WELD
USING TOOL
DT8209

TYP E

D2249-041 ASSEMBLY

MATERIAL: AISI 304/316 SS, 0.063 THICK
WELD PER DART QSI 004
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED



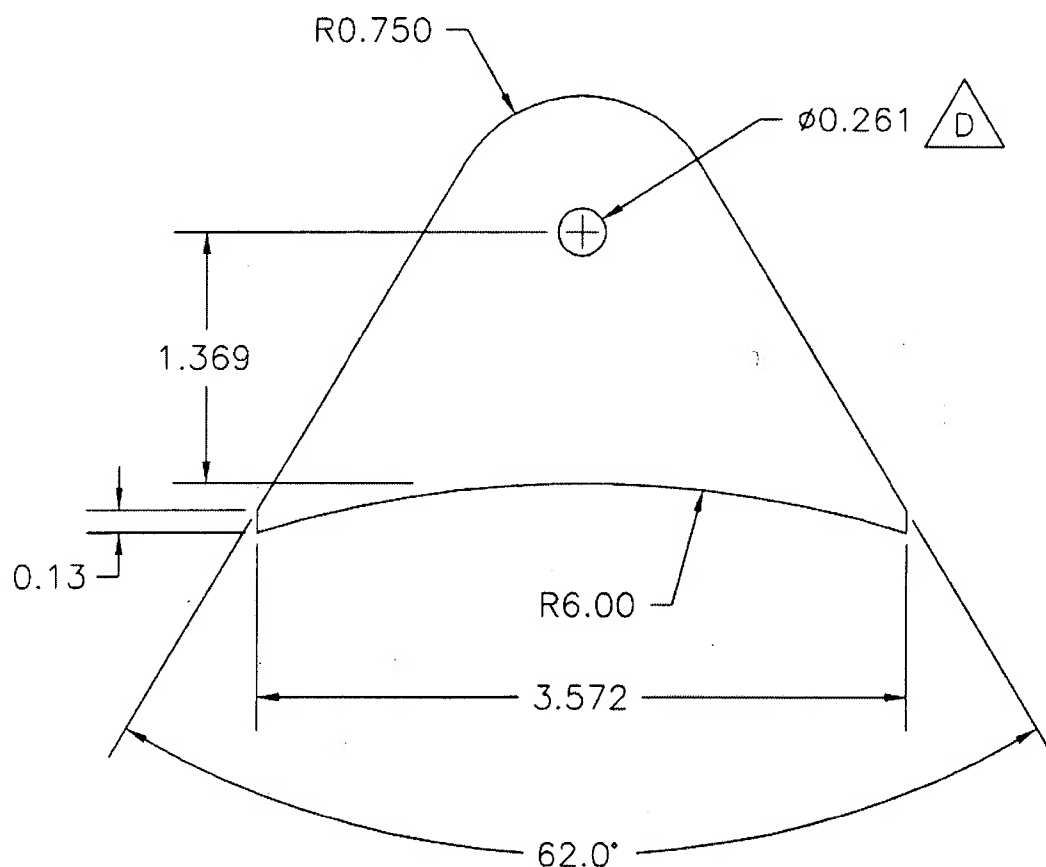
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WORK ORDER
NO. 34671A



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DATE 99.09.20	TITLE FITTING		SCALE 1:1

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99.10.12 KE



D2249-1 LUG

MATERIAL: AISI 304/316 SS 0.063 THICK

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

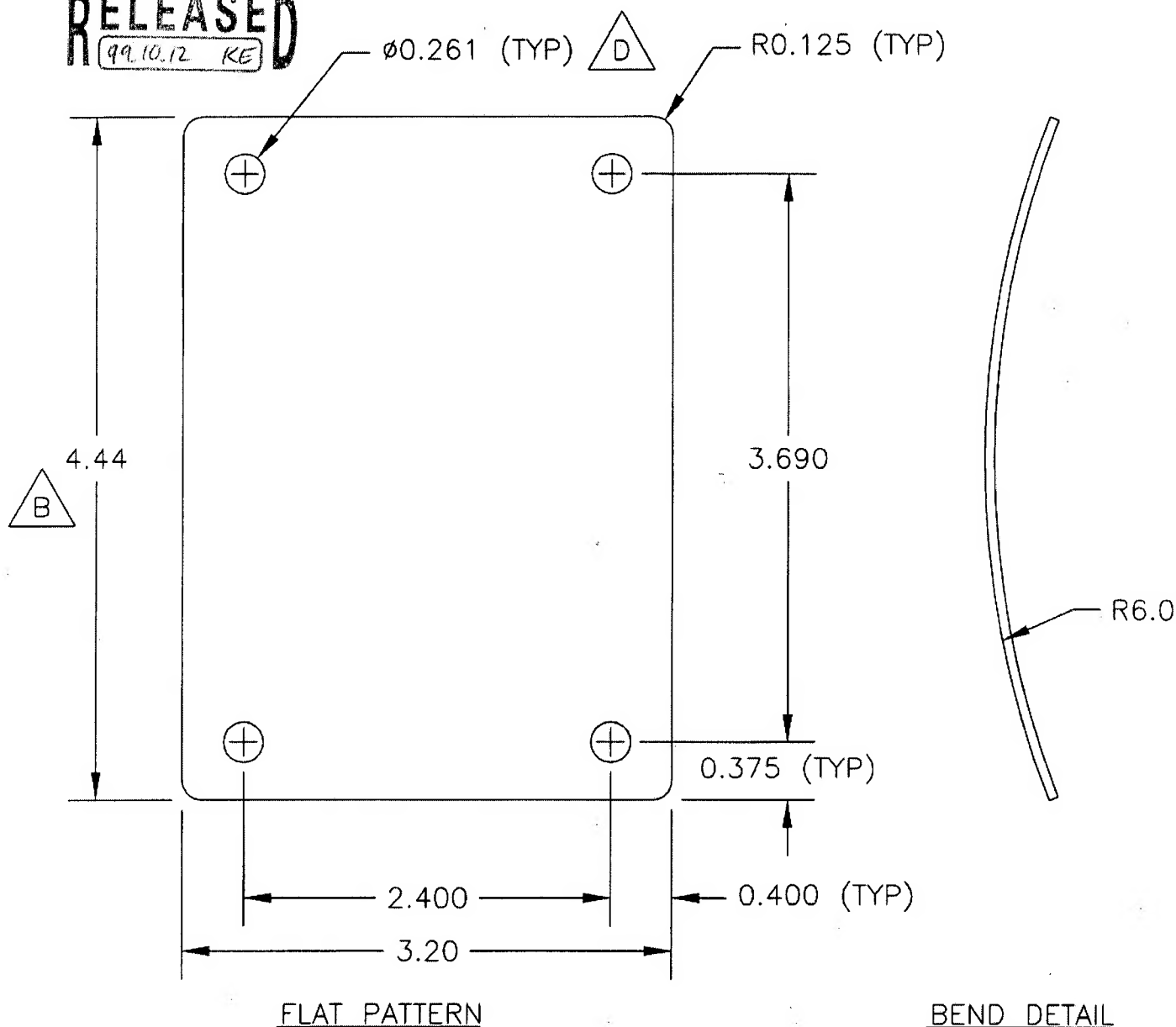
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NO. 34671A



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DATE 99.09.20		TITLE FITTING	SCALE 1:1

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FLAT PATTERN

BEND DETAIL

D2249-3 BASE PLATE

MATERIAL: AISI 304/316 SS 0.063 THICK

ALL DIMENSIONS ARE IN INCHES

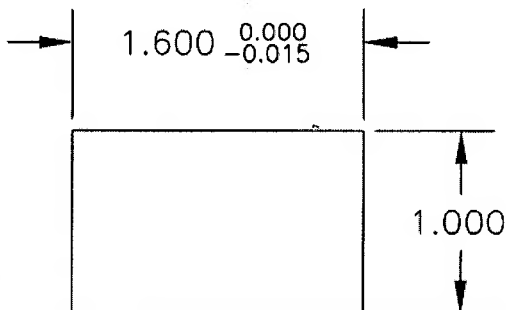
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CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2249	REV. E SHEET 4 OF 4
DATE 99.09.20		TITLE FITTING SCALE 1:1	

RELEASED
99.10.12 KE



D2249-5 GUSSET

MATERIAL: AISI 304/316 SS 0.063 THICK
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